5								.	
Work Order I					·				Page 1
Revision ID: Item Name: Wear Start Date: 8/31	35-25 rshoe /2010* Start Qty: 10.00		ccept	Cust Item I			S	etup Star Stop	
Required Date: 9/7/2 Reference:	2010 Req'd Qty: 10.00			Customer:					
Approvals: Pro	ocess Plan:	Date://0-8-3/	Tooling: SPC (Y/N):		te:		R	un Star Stop	1
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								
Waterjet FLOW CNC Waterjet 304.040	FLOW WATER JET Memo 1-Cut as per Deburr if neo	Dwg D3535 □Dwg Rev:_ cessary	0.00 0.00 S □Prog Rev:	<u>B</u> ====================================		_	_R(0-9-15	- (1)
110	QC2- Inspect parts off ma	achine FAI/FAIB	0.00					. C	
QC Quality Control	Memo		0.00			_	<u>\{\}</u>	0-9-15	

0.00 Colonlis

QC8- Inspect parts - second check

Memo

Quality Control

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву		ate	Qty	Approval Chief Eng /	Approval. QC Inspector
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D.4.T.F	0750	Description of NC			tion B		Verificat	ion	Approval	Approval
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Work	Orde	r ID	617	ሰራ
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Tuesday, August 31, 2010 1:46:03 PM



Page 2

Item ID:

D3535-25

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Wearshoe

Required Date: 9/7/2010

8/31/2010

Start Qty: 10.00

Req'd Qty: 10.00

Operation

NC BRAKE

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept **Oty**

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Memo

0.00

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

Spiologlic

140

QC

QC5- Inspect part completeness to step on W/O

0.00

0.00 8 work 6

Quality Control

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

□OVEN TEMPERATURE:

W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng /	Approval. QC Inspector
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Work Order ID 61706

Page 3

Tuesday, August 31, 2010 1:46:03 PM

Item ID:

D3535-25

Revision ID: Item Name:

Wearshoe

Start Date:

8/31/2010

Required Date: 9/7/2010

Req'd Qty: 10.00



Accept



Run

Setup Start

Stop



Start Qty: 10.00 Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Start

Stop

Reject



Accept

Sequence ID/ Work Center ID

160

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

=> MI 10/09/20

Tool ID

Code Qty **Qty**

Insp. Number Stamp

Reject

170

Packaging

Packaging

Memo

0.00

Identify as per dwg & Stock Location PR 0.00 PR 10-9-30

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10 (09/2) 15 MF 10-9-20

W/O:			W	ORK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·		·
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Picklist Print

Tuesday, August 31, 2010 1:46:35 PM

Work Order ID: 61706

D3535-25 Parent Item:

Parent Item Name:

Wearshoe



Start Date: 8/31/2010

Required Date: 9/7/2010

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Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

M304S20GA Purchased No 100 sf 111.7987 0.51 5.368421			
304/316 .040 Sheet	##	100 sf 111.7987 0.51 5.36842	1 1B10-9-15

Location	ļ	Loc Oty	Loc Code	
MAT		16.1522		
	114574	16.1522		114574
MAT20		95.6465		
	112885	2.7475		
	113062	0.699		
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DART AEROSPACE LTD	Work Order:	41704
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

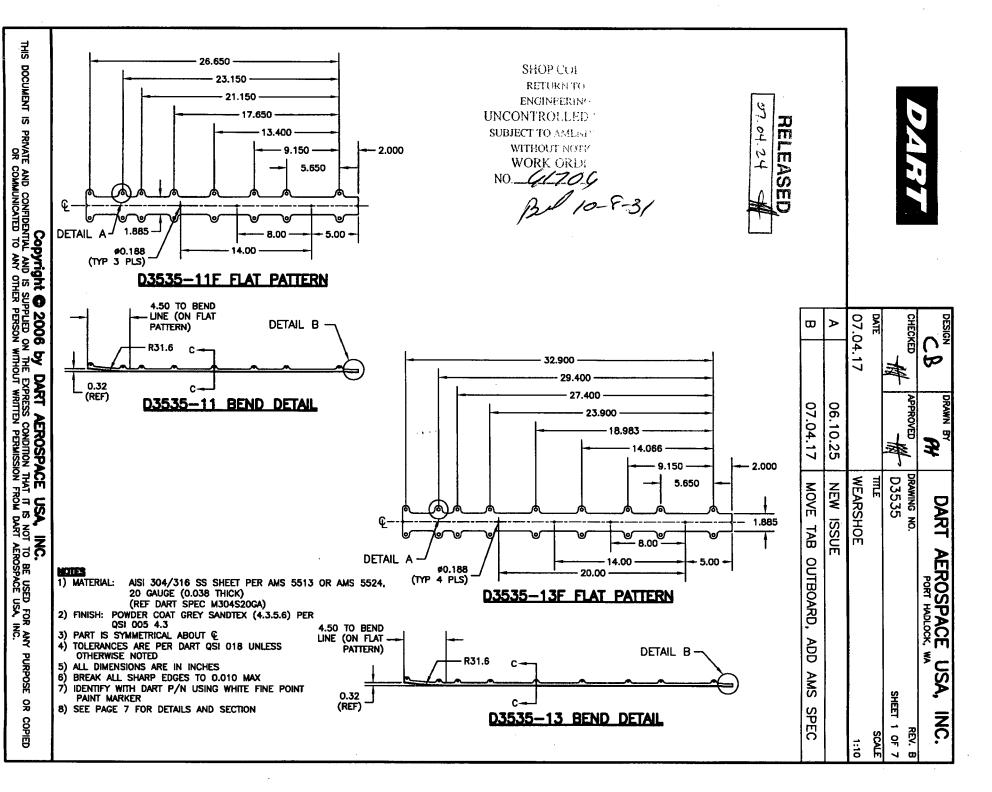
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.450	+/-0.010	1.453	70		V	
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Date:	10-9-15	Date: lolos lis	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD , X	
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W/O:		WORK ORDER CHANGES											
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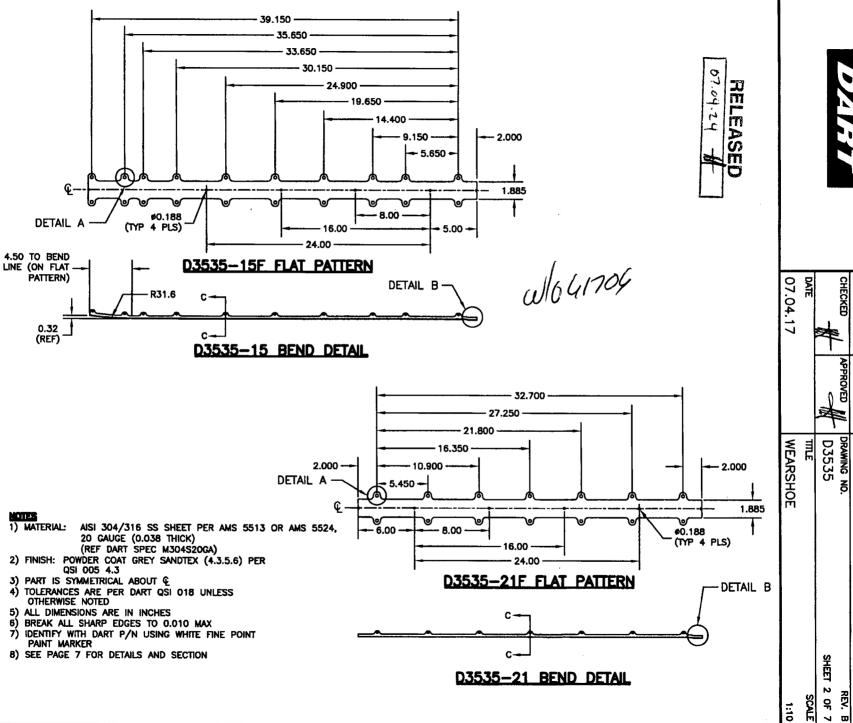
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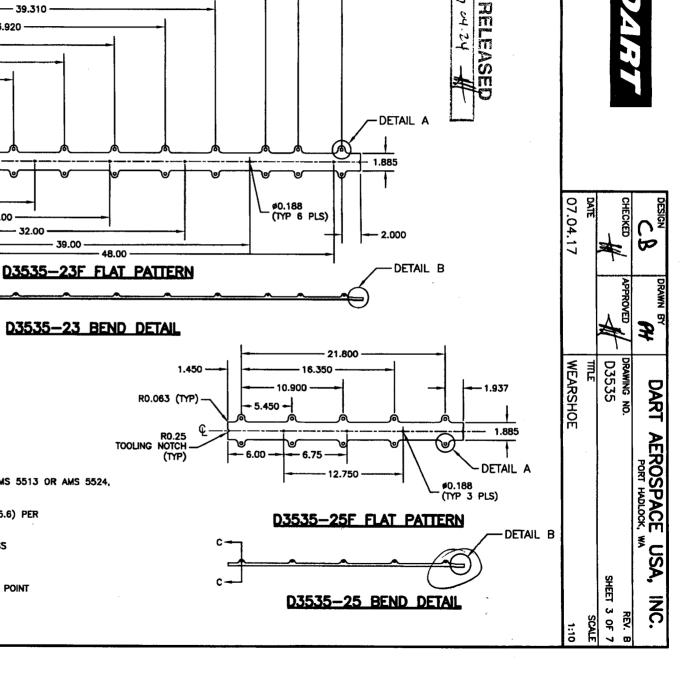
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PURPOSE

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

24.00

32.00

39.00

48.00

17.750 14.250

9.500

4.750

6.00

QSI 005 4.3 3) PART IS SYMMETRICAL ABOUT &

5) ALL DIMENSIONS ARE IN INCHES

PAINT MARKER

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT

BREAK ALL SHARP EDGES TO 0.010 MAX

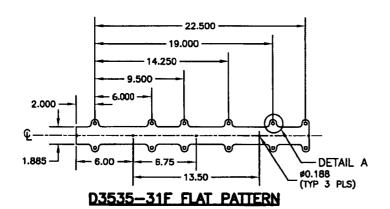
8) SEE PAGE 7 FOR DETAILS AND SECTION

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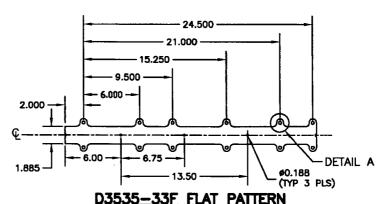


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PURPOSE

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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX 6)
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION





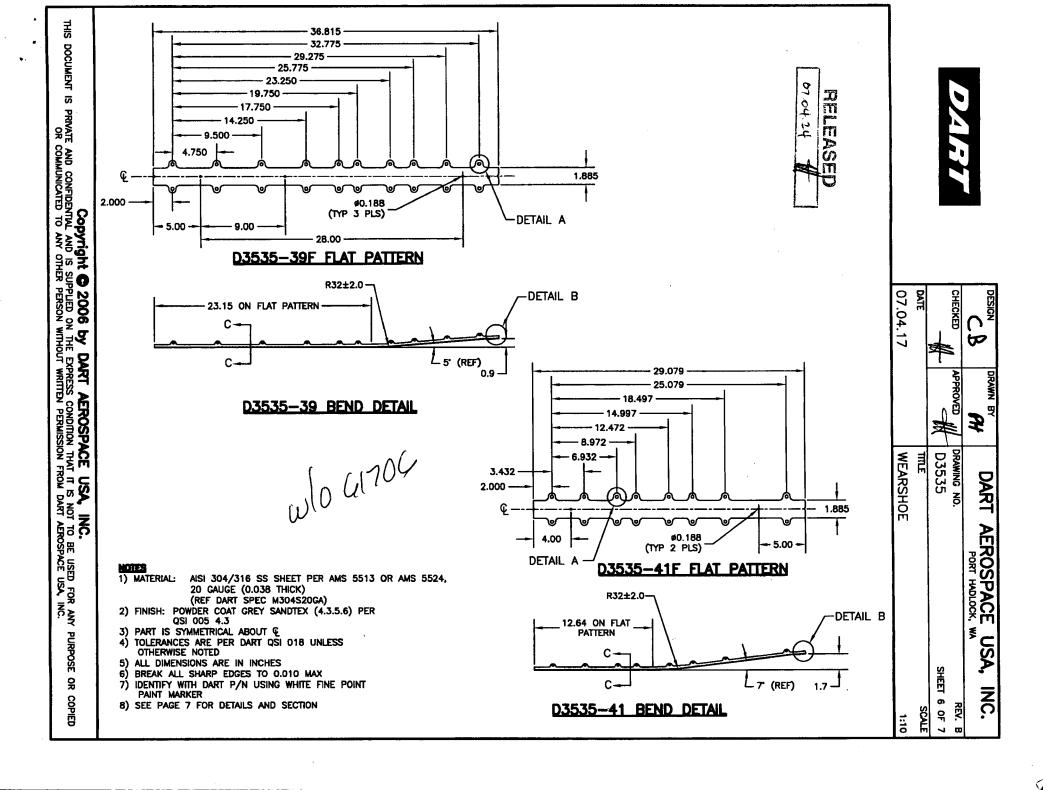
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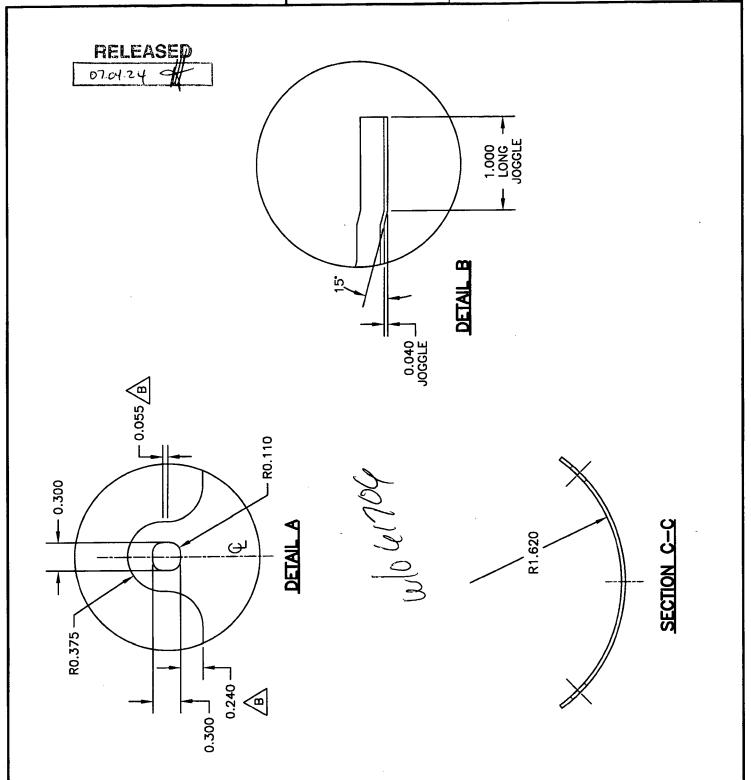
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07.04.17		WEARSHOE	1:1



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